

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020498**Date Inspected:** 24-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path/Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 010 located on BK004A3-033. Welder is identified as 056200. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 032 located on BK005B-034. Welder is identified as 053486. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 033 located on BK004A1-022. Welder is identified as 040704. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 015 located on BK004A2-003. Welder is identified as 066155. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07907.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:
SD1-BRSA5-1-19A/B

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07912.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:
HW-SAW1-119M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-127M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-139M-W(N)-1-1, 2, 3, 4
HW-SAW1-131M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-135M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-123M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-143M-W(N)-1,2-1, 2, 3, 4

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07914.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:
BK004A5-031-112, 115, 118, 121, 122, 125, 128, 131, 014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045
BK004A5-031-064, 065, 084, 085, 110, 111, 113, 114, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133
BK004A3-031-021, 022, 045, 046
BK004A4-031-004, 005, 031, 032, 056, 057
BK004A3-031-030, 031, 056, 057
BK004A4-031-019, 020, 045, 046, 071, 072
BK004A2-031-001, 003, 004, 005, 006
BK004A3-031-019, 020, 043, 044
BK004A4-031-006, 007, 032, 033, 058, 059
BK004A2-031-007, 009, 010, 011, 012

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BK004A3-031-032, 033, 058, 059
BK004A4-031-073, 074
BK004A6-031-072, 073
BK004A8-031-072, 073
BK004A5-031-004, 007
BK004A3-031-005, 009

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07912.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

HW-SAW1-119M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-127M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-139M-W(N)-1-1, 2, 3, 4
HW-SAW1-131M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-135M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-123M-W(N)-1,2-1, 2, 3, 4
HW-SAW1-143M-W(N)-1,2-1, 2, 3, 4

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07914.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK004A5-031-112, 115, 118, 121, 122, 125, 128, 131, 014, 015, 034, 035, 054, 055, 074, 075, 024, 025, 044, 045
BK004A5-031-064, 065, 084, 085, 110, 111, 113, 114, 116, 117, 119, 120, 123, 124, 126, 127, 129, 130, 132, 133
BK004A3-031-021, 022, 045, 046
BK004A4-031-004, 005, 031, 032, 056, 057
BK004A3-031-030, 031, 056, 057
BK004A4-031-019, 020, 045, 046, 071, 072
BK004A2-031-001, 003, 004, 005, 006
BK004A3-031-019, 020, 043, 044
BK004A4-031-006, 007, 032, 033, 058, 059
BK004A2-031-007, 009, 010, 011, 012
BK004A3-031-032, 033, 058, 059
BK004A4-031-073, 074
BK004A6-031-072, 073
BK004A8-031-072, 073
BK004A5-031-004, 007
BK004A3-031-005, 009

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Ultrasonic Testing Inspection (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07907.

This QA inspector performed UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report for this date.

The members are identified as:

SD1-BRSA5-1-19A/B

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt, Scott
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Quality Assurance Inspector

Reviewed By:	Clifford, William
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QA Reviewer
